

slg Jm12

Work Order ID 78028

December-28-11 8:08:04 AM

78028

Page 1

Item ID: D4030-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Long Basket Assembly (350)
 Start Date: 28/12/2011 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/01/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: M.C.S Date: 11/12/12 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4030	C								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
110									
HandFinish	Memo	0.00							
Hand Finishing	****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

12/01/12

1 BR 12 1-9.

(70)

Sizdala

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78028***78028***

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Item ID: D4030-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Assembly (350)
Start Date: 28/12/2011 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/01/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00		PPP 78028					12/1/13
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							CK 12/1/13
Quality Control									

MF
12-1-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

December-28-11 8:08:09 AM

Page 1

Work Order ID: 78028

78028

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg
revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-210 *D4086-210* Placard, Max Load		Manufactured	No				Each	12.0000		1			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST122				11					
				66275				1					
				76298				10		76298			
				ST124				1					
				64869				1					
D2530 *D2530* Handle Weldment		Manufactured	No			100	Each	20.0000	1	1			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST506				20					
				76087				10		76087			
				77030				10					
D2535 *D2535* Spring		Manufactured	No			100	Each	80.0000	2	2			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST504				80					
				71117				30		71117			
				77488				50					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2537

Manufactured No

100 Each

38.0000

2 2

D2537

Bushing

**

Location

Loc Qty

Loc Code

ST504

38

73344

7

76088

31

73377

D3913-041

Manufactured No

100 Each

0.0000

1 1

D3913-041

Long Basket Base Assembly, 350

D3914-041

Manufactured No

100 Each

0.0000

1 1

D3914-041

Long Basket Lid Assembly (350)

D3917-3

Manufactured No

100 Each

41.0000

6 6

D3917-3

Washer

**

Location

Loc Qty

Loc Code

ST092

41

75036

17

76956

24

75036

D3953-3

Manufactured No

100 Each

2.0000

2 2

D3953-3

Gas Spring Stud, Lid

**

Location

Loc Qty

Loc Code

ST096

2

74703

2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-7 Manufactured No

100 Each 30.0000 2 2

D3953-7

Spring Spacer

**

Location Loc Qty Loc Code

ST096 30

76295 22

76658 8

D3953-9 Manufactured No

100 Each 14.0000 2 2

D3953-9

Gas Spring Washer

**

Location Loc Qty Loc Code

ST096 14

74169 4

76296 10

D3953-17 Manufactured No

100 Each 23.0000 2 2

D3953-17

Gas Spring Spacer

**

Location Loc Qty Loc Code

ST096 23

76294 23

D3953-19 Manufactured No

100 Each 22.0000 1 1

D3953-19

Gas Spring Bracket

**

Location Loc Qty Loc Code

ST096 22

73551 2

75227 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-21
D3953-21
Gas Spring Bracket

Manufactured	No	100	Each	9.0000	1	1
**						

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST096	9	
73557	9	

73557
1 -

D3969-3
D3969-3
Spring (Basket Lid)

Manufactured	No	100	Each	23.0000	1	1
**						

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST272	23	
64285	1	
73515	22	

73515
4 -

AN3-14A
AN3-14A
Bolt

Purchased	No	100	Each	132.0000	4	4
**						

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST352	132	
117872	32	
119328	100	

117872

AN3-16A
AN3-16A
Bolt

Purchased	No	100	Each	121.0000	2	2
**						

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST352	121	
117441	49	
118628	72	

118628

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 78028

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

78028

D4030-041

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-17A Purchased No

100 Each 104.0000 4 4

AN5-17A

Bolt

**

Location	Loc Qty	Loc Code
FP001	50	
119438	50	
ST338	54	
117872	42	
119449	12	

AN4-12 Purchased No

100 Each 65.0000 3 3

AN4-12

Bolt

**

Location	Loc Qty	Loc Code
ST357	65	
118626	40	
119775	25	

AN310-4 Purchased No

100 Each 31.0000 3 3

AN310-4

NUT

**

Location	Loc Qty	Loc Code
ST344	31	
119328	16	
119799	15	

AN310C4 Purchased No

100 Each 44.0000 2 2

AN310C4

Nut

**

Location	Loc Qty	Loc Code
ST344	44	
118626	19	
119324	25	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 6

Work Order ID: 78028

78028

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

6,837.000

6

6

MS21042I 3

Nut

**

Location

Loc Qty

Loc Code

ST300

6837

117441

16

117885

32

118451

5

118927

3

119017

5988

119075

793

119017

MS21042L5

Purchased

No

100

Each

2,112.000

4

4

MS21042I 5

Nut

**

Location

Loc Qty

Loc Code

ST300

2112

116105

5

116548

43

117611

50

118179

496

118910

18

119109

1500

118179

MS24665-151

Purchased

No

100

Each

362.0000

3

3

MS24665-151

Cotter Pin

**

Location

Loc Qty

Loc Code

ST309

362

17566

362

17566

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 7

Work Order ID: 78028

78028

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS24665-300

Purchased

No

100

Each

226.0000

2

2

MS24665-300

**

Cotter Pin

LocationLoc QtyLoc Code

GA

200

118234

200

ST309

26

116823

26

212.0000

6

6

NAS1149F0432P

Purchased

No

NAS1149F0432P

**

Washer

LocationLoc QtyLoc Code

ST275

212

119307

12

119638

200

131.0000

4

4

NAS1149F0563P

Purchased

No

NAS1149F0563P

**

Washer

LocationLoc QtyLoc Code

ST275

131

117735

131

348.0000

8

8

NAS1149F0332P

Purchased

No

NAS1149F0332P

**

WASHER

LocationLoc QtyLoc Code

ST275

348

117735

45

119225

300

17317

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 78028

78028

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

100

Each

3,780.000

2

2

NAS1149C0432R

**

Washer

Location

Loc Qty

Loc Code

ST297

3780

117291

2780

119124

1000

117291

12/01/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

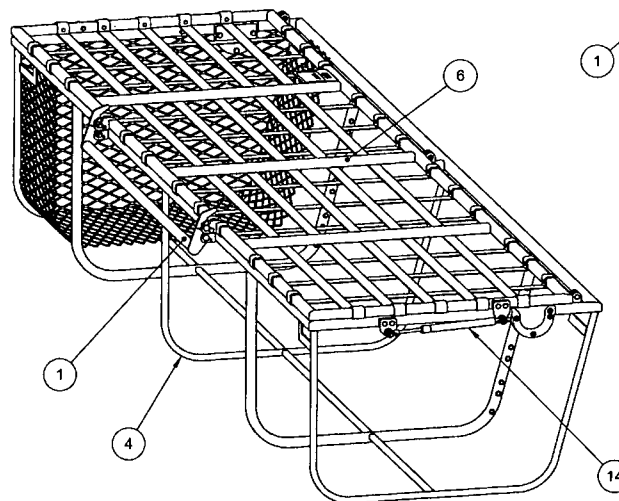
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

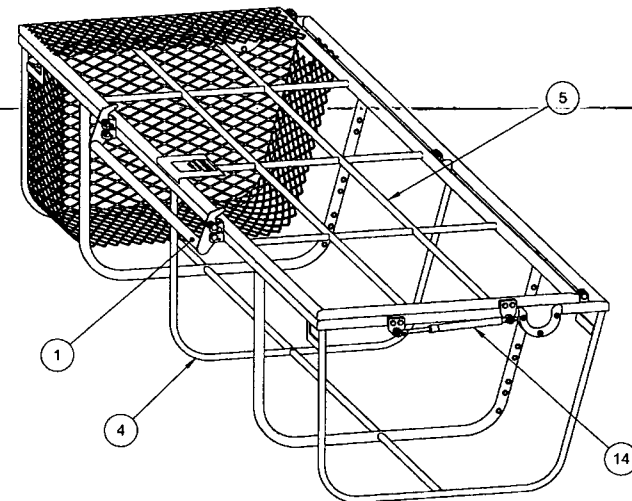
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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOWN
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 78028-M.L.J
11/12/20

RELEASED
10-08-12
ECN 10-546

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AS		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	10.07.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4030
TITLE LONG BASKET ASSY (350)
REV. C
SHEET 1 OF 3
SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

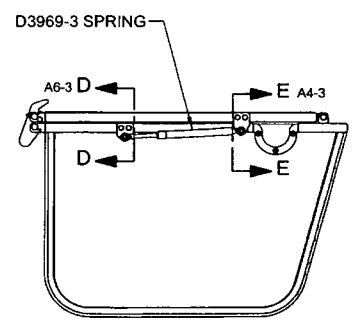
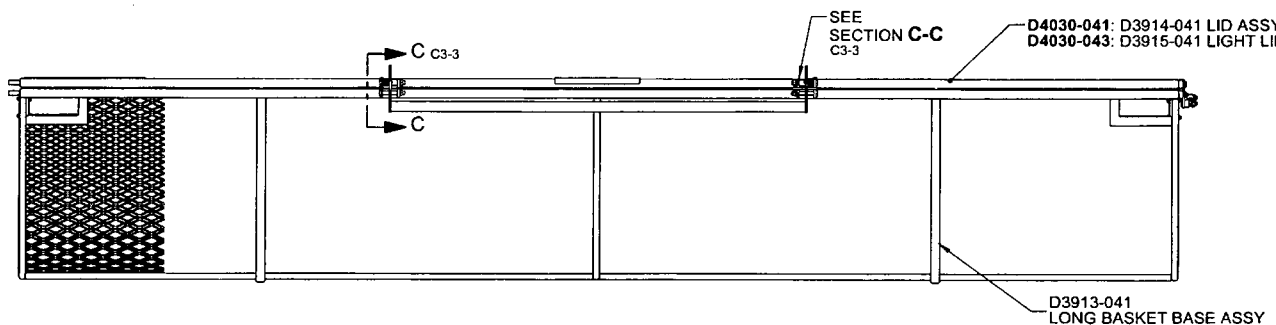
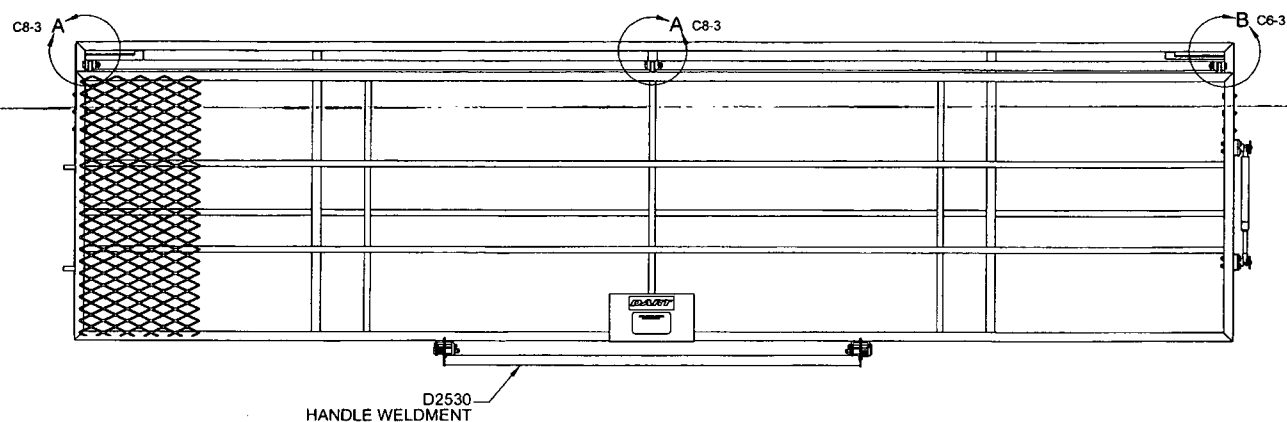
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NOTE: Date & initial all entries

78028



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	SES	D4030	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350) ____ _NTS.	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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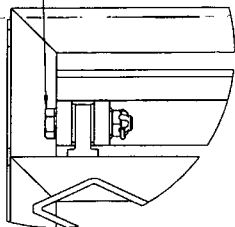
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

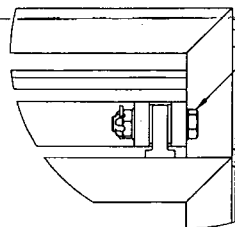
78028

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



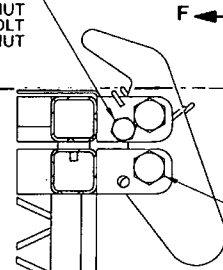
DETAIL A D8-2
D5-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



DETAIL B D3-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

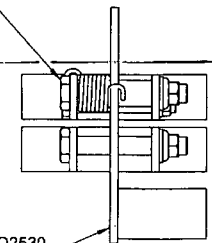


SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

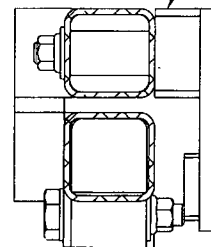
D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL



D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10.08.124

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	3	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4030	SHEET 3 OF 3
APPROVED	UP	TITLE	SCALE
DE APPR.	UP	LONG BASKET-ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries